

Work Order ID 80197***80197***

Page 1

February-14-12 9:06:57 AM.

Item ID: D3267-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket lid Assembly (Outside)

Start Date: 14/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *M.L.S*Date: *12/02/14* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3267	Rev C								

100

Weld per dwg A/R S.S. rod Batch: *h.118366* 0.00
Large Fab***100***

Large Fab

Large Fab

Memo

0.00

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-041 as per Dwg D3267

4-Deburr & Remove All Markings From Material

5-Weld D3267-041 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

6-Drill Ø0.257" hole in D3267-041 as per Dwg D3267 Identify as D3267-041

1x *Ø* *PC12.05.07*
dy 12.05.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80197

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Accept

N9000040100

Setup Start *NS1*

Revision ID:

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Item Name: Basket lid Assembly (Outside)

Start Date: 14/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

12-05-07

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

5/2/07

A

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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 Item Name: Basket lid Assembly (Outside)
 Start Date: 14/02/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 23/02/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

130

Powdercoat

Powder Coating

Memo

0.00

POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT

START TIME: 1:00

OVEN TEMPERATURE: 400°F

FINISH TIME: 1:20

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

140

HandFinishing

0.00

140

HandFinish

Hand Finishing

Memo

0.00

Wing walk as per Dwg D3267 and QSI 005 4.4

Spray Paint Black: 118107

Wing Walk: 121121

M121134

IX 12/05/07

1 BL 2-5-7

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Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 1.00

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Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

155

Identify as per dwg & Stock Location

D350-607047

80191

155

Packaging

Memo

0.00

Packaging

1 φ 121358

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/5/8

ME 12-05-08

W/O:		WORK ORDER CHANGES					
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Picklist Print

February-14-12 9:07:01 AM

Page 1

Work Order ID: 80197

80197

Parent Item: D3267-041

D3267-041

Parent Item Name: Basket lid Assembly (Outside)

Start Date: 14/02/2012

Required Date: 23/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C Removed -043 05-11-04 JLM
IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified
by:EC IPP Rev:E add I.D. DD 10.03.11 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3		Manufactured	No			100	Each	10.0000	2	2			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2327-3
Spacer Bushing

**

Location

Loc Qty

Loc Code

WA005

10

75564

1

77229

9

D2506		Manufactured	No			100	Each	2.0000	1	1			
-------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D2506
Label Plate

**

Location

Loc Qty

Loc Code

WA006

2

74142

2

D2581		Manufactured	No			100	Each	57.0000	2	2			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2581
Mounting Bracket

**

Location

Loc Qty

Loc Code

WA005

57

69739

1

70766

2

77045

25

77523

29

PC 12.05.07
382706 → ②

PC 12.05.07
379197 → ①

PC 12.05.07
382017 → ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

February-14-12 9:07:01 AM

Page 2

Work Order ID: 80197

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Parent Item: D3267-041

D3267-041

Parent Item Name: Basket lid Assembly (Outside)

Start Date: 14/02/2012

Required Date: 23/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3166-3 Manufactured No

100 Each 5.0000 1 1

D3166-3

Basket Hoop

**

Location

Loc Qty

Loc Code

WA007

5

77294

5

100 sf

643.1751

7.8

8.210526

**

M304EX0.75-16F

Purchased

No

M304FX0 75-16F

Expanded Metal Flat SS

Location

Loc Qty

Loc Code

WA

0.0001156

119180

0.0001156

WA035

643.1749720

117197

102.9036

117896

29.49258

118153

76.8473

118955

82.17

119180

53.6958107

119729

28.1132686

120153

13.2387327

120318

256.71368

100 f

705.3363

30.6

32.21053

**

M304TS0.750W.065

Purchased

No

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT017

698.67885

120267

198.67885

120633

500

WA007

0.5907428

116763

0.5907428

WA035

6.0667

118181

6.0667

February-14-12 9:07:01 AM

Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

80197 H.C.J
12/02/14

RELEASED
08-09-14



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3267	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BASKET LID ASSEMBLY	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

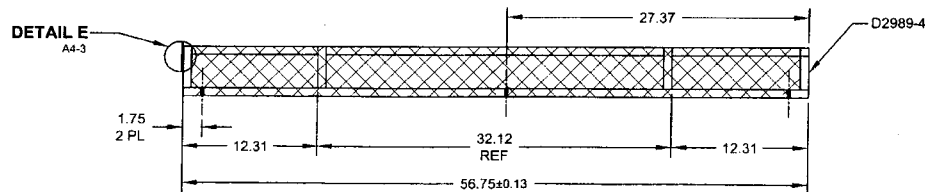
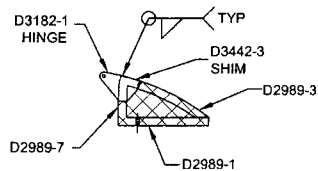
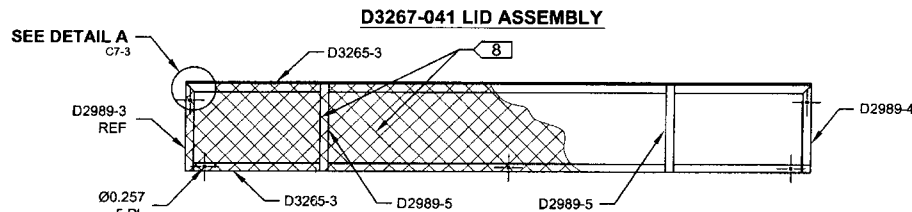
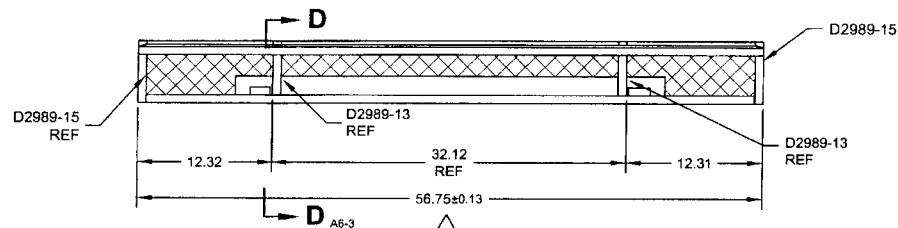
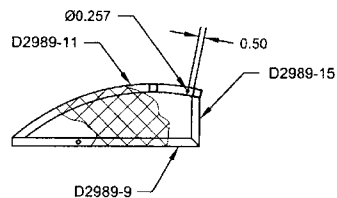
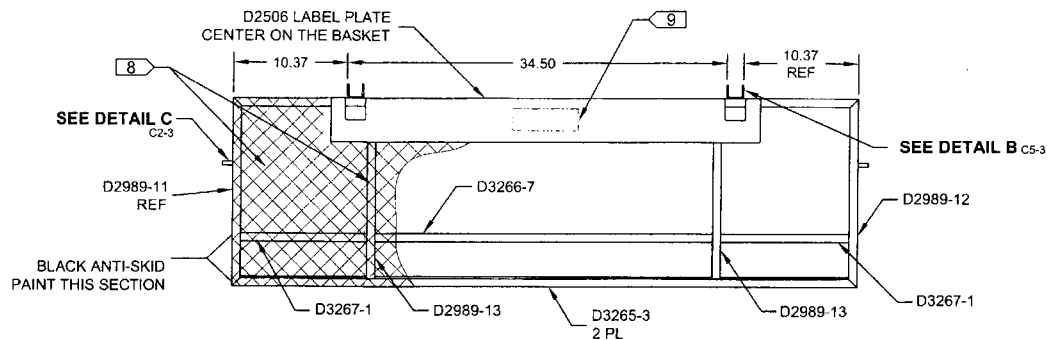
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NOTE: Date & initial all entries

80197



NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) SKIN WITH EXPANDED STEEL MESH. TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION.
- 9) REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

D3267-041 LID ASSEMBLY

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
08.07.04/10

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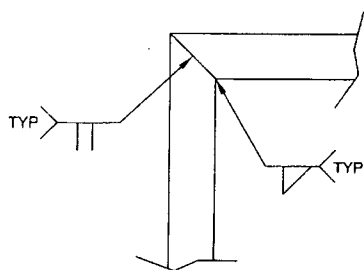
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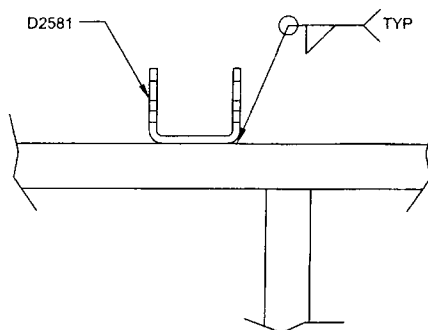
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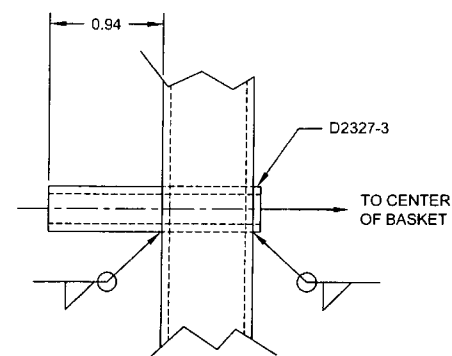
80197



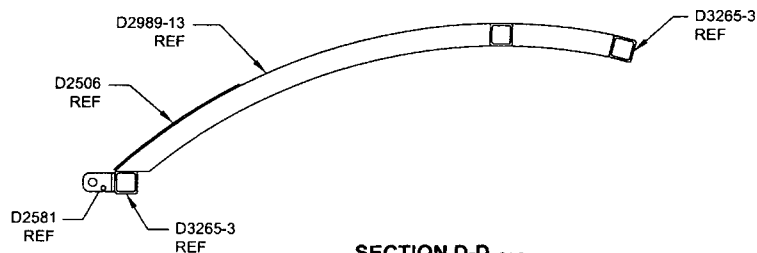
DETAIL A B5-2
JOINT WELD DETAIL TYP
SCALE 2X



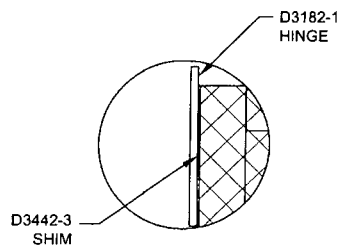
DETAIL B D2-2
2 PL
SCALE 2X



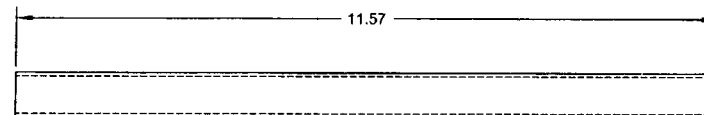
DETAIL C D5-2
SPACER INSTALLATION
SCALE 4X



SECTION D-D C4-2



DETAIL E B6-2
SCALE 2X
2 PL



D3267-1 STRUT
SCALE 2X

RELEASED
08-07-07

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSMEBLY	NTS
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